

Blue

Work Order ID 81799

81799

Page 1

March-19-12 1:33:21 PM

Item ID: D206-628-026BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crew Step, RH, Blue

Start Date: 19/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|---|
| D4308 | A |
|-------|---|

| | |
|--------------|---|
| IIN-D206-628 | G |
|--------------|---|

100

0.00

100

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

JB Sedletzky

MLJ 12-5-23

(4)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/05/23 JB

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 81799

81799

Page 2

March-19-12 1:33:21 PM

Item ID: D206-628-026BL

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crew Step, RH, Blue

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 230 | Identify as per dwg & Stock Location: <i>Draft</i> | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Package per PPP D206-628-026 | | | | | | | | |
| 240 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

*74
R4*

4x

12529

12/5/30

*ME
12-05-29*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

March-19-12 1:33:25 PM

Page 1

81799

*D206-628-026BI *

Required Qty: 4.00

Comments: IPP rev A 11.05.26 new issue EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D4308-042 | | Manufactured | No | | | | Each | 0.0000 | | 4 | | | |
| <div> <div>*D4308-042*</div> <div>Step, RH Crew</div> <div>BLUE</div> </div> | | | | | | | | | | | | | |
| D2731-7RG | | Manufactured | No | | | | Each | 2.0000 | | 8 | | | |
| <div> <div>*D2731-7RG*</div> <div>Mounting Lug</div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | <u>Loc Code</u> | | | |
| | | | | ST423 | | | 2 | | | | | | |
| | | | | 79608 | | | 2 | | | | | | |
| BLUE | | | | | | | | | | | | | |
| D3394-3RG | | Manufactured | No | | | | Each | 12.0000 | | 8 | | | |
| <div> <div>*D3394-3RG*</div> <div>Lug</div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | <u>Loc Code</u> | | | |
| | | | | ST469 | | | 12 | | | | | | |
| | | | | 80248 | | | 12 | | | | | | |
| BLUE | | | | | | | | | | | | | |
| D4309-1 | | Manufactured | No | | | | Each | 30.0000 | | 8 | | | |
| <div> <div>*D4309-1*</div> <div>Bushing</div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | <u>Loc Code</u> | | | |
| | | | | ST139C | | | 30 | | | | | | |
| | | | | 78924 | | | 30 | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

March-19-12 1:33:25 PM

Page 2

Work Order ID: 81799

81799

Parent Item: D206-628-026BL

*D206-628-026BL *

Parent Item Name: Crew Step, RH, Blue

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-11A

Purchased

No

Each

246.0000

Sy ***AN4-11A***
Bolt

**

4 16 ✓

JB

Location

Loc Qty

Loc Code

ST356

246

117872

46

118706

100

120731

100

118706 ✓

AN4-12A

Purchased

No

Each

683.0000

Sy ***AN4-12A***
Bolt

**

4 16 ✓

JB

Location

Loc Qty

Loc Code

ST357

683

115422

4

118628

29

119775

50

120423

600

120423 ✓

AN4-15A

Purchased

No

Each

367.0000

Sy ***AN4-15A***
Bolt

**

2 8 ✓

JB

12/05/23

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

267

118706

15

120187

52

120422

200

120422 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

March-19-12 1:33:25 PM

Page 3

Work Order ID: 81799

81799

Parent Item: D206-628-026BL

*D206-628-026BL *

Parent Item Name: Crew Step, RH, Blue

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042-4

Purchased

No

Each

1,248.000

MS21042-4

USE MS21042L4

**

6 24

Location

Loc Qty

Loc Code

ST299

1248

100743

9

119124

1000

5389

66

5461

3

6844

19

7690

24

8182

115

9063

8

9229

4

8182 5

NAS1149D0463.1

Purchased

No

Each

2,983.000

NAS1149D0463.1

Washer

**

6 24

121255 JB

12/05/23

Location

Loc Qty

Loc Code

ST297

2000

121011

2000

ST298

983

116805

0

118384

20

119097

169

120644

794

March-19-12 1:33:25 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

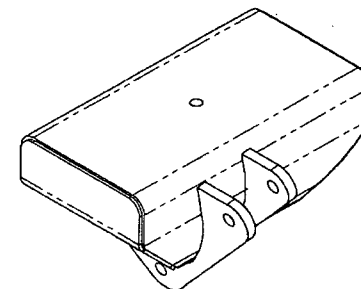
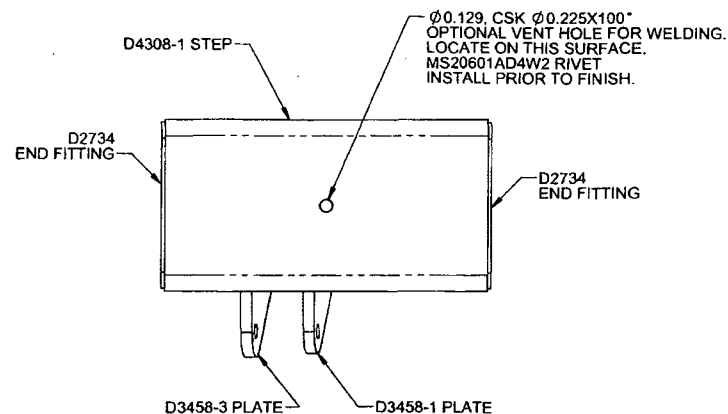
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

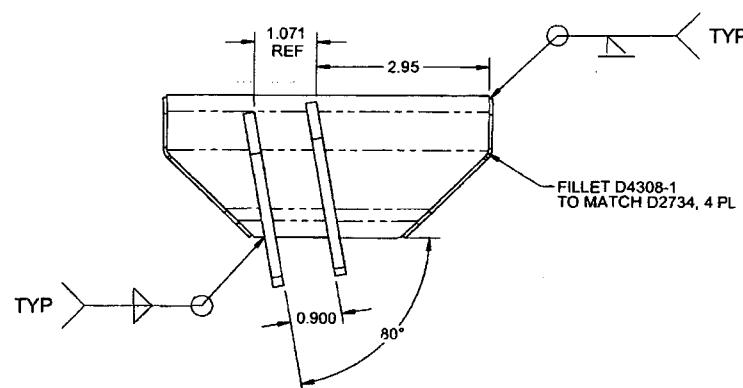
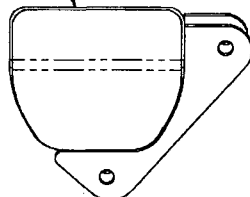
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|--------------|------------------|
| 1 | X | D4308-041 | STEP, LH CREW |
| 2 | 1 | D4308-1 | STEP |
| 3 | 2 | D2734 | END PLATE |
| 4 | 1 | D3458-1 | PLATE |
| 5 | 1 | D3458-3 | PLATE |
| 6 | 1 | MS20601AD4W2 | RIVET (OPTIONAL) |



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81799 MCT

12/03/19

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

| REV. | NEW ISSUE | DESCRIPTION | CP | 10.12.17 |
|------------|-----------|-------------|----|----------|
| DESIGN | | | BY | DATE |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 10.12.17 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4308** REV. A
SHEET 1 OF 3
TITLE **STEP, CREW** SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

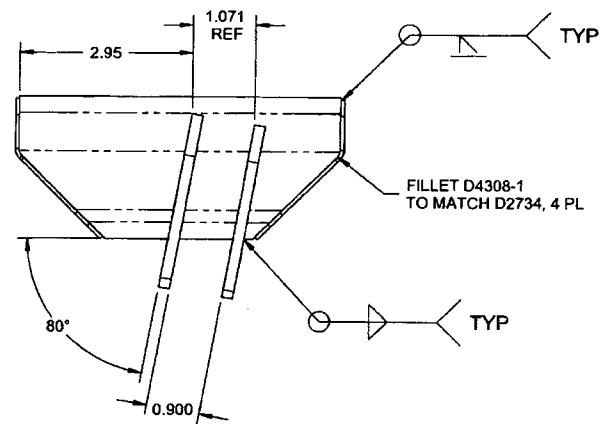
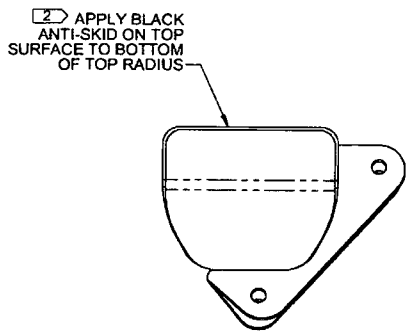
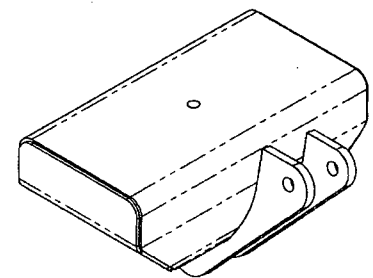
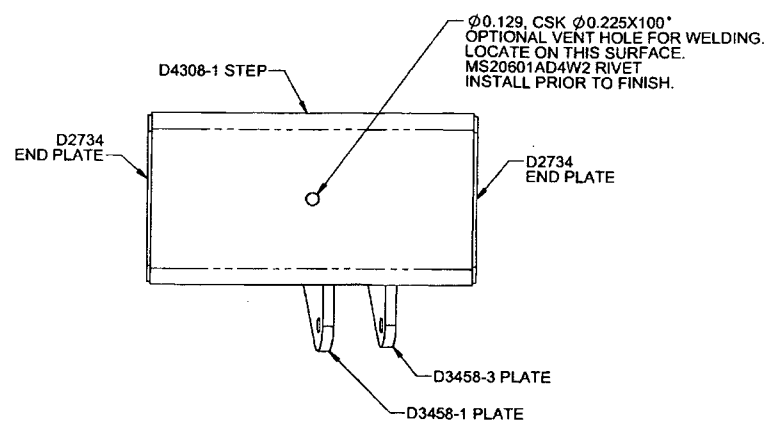
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

81799

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|------------------|
| 1 | X | D4308-042 | STEP, RH CREW |
| 2 | 1 | D4308-1 | STEP |
| 3 | 2 | D2734 | END PLATE |
| 4 | 1 | D3458-1 | PLATE |
| 5 | 1 | D3458-3 | PLATE |
| 6 | 1 | MS20601AD4W2 | RIVET (OPTIONAL) |



D4308-042 STEP, RH CREW

RELEASED
2011-05-34
JH

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
 - 7) WEIGHT: 0.47 lbs
 - 8) WELDING: PER DART QSI 004

| | | |
|------------|----------|-----------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. A |
| MFG. APPR. | | D4308 SHEET 2 OF 3 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | STEP, CREW NTS |
| DATE | 10.12.17 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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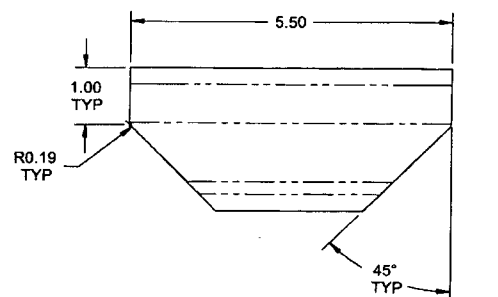
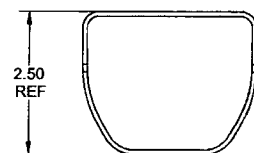
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

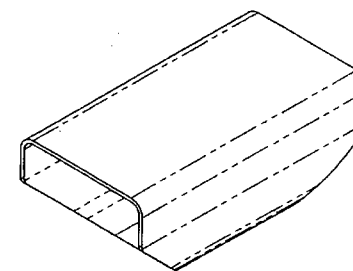
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

81799



3.00
REF



D4308-1 STEP

RELEASED
2011-05-20
MM

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | GP | DART AEROSPACE LTD | |
| DRAWN | GP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. A |
| MFG. APPR. | MD | D4308 | SHEET 3 OF 3 |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | MD | STEP, CREW | NTS |
| DATE | 10.12.17 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.4 CREW STEP PARTS LIST

| Qty -015 | Qty -016 | Qty -025 | Qty -026 | Qty -035 | Qty -036 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|--------------------------------|
| X | | | | | | D206-628-015 | CREW STEP, LH 206A/B |
| | X | | | | | D206-628-016 | CREW STEP, RH 206A/B |
| | | X | | | | D206-628-025 | CREW STEP, LH 206L/L-1/L-3/L-4 |
| | | | X | | | D206-628-026 | CREW STEP, RH 206L/L-1/L-3/L-4 |
| | | | | X | | D206-628-035 | CREW STEP, LH 407 |
| | | | | | X | D206-628-036 | CREW STEP, RH 407 |
| | | | | | | | |
| | | | | 2 | 2 | D2731-3RG | MOUNTING LUG |
| 2 | 2 | 2 | 2 | | | D2731-7RG | MOUNTING LUG |
| | | | | 2 | 2 | D3394-1RG | MOUNTING LUG |
| 2 | 2 | 2 | 2 | | | D3394-3RG | MOUNTING LUG |
| | | 1 | | 1 | | D4308-041 | CREW STEP, LH |
| | | | 1 | | 1 | D4308-042 | CREW STEP, RH |
| 2 | 2 | 2 | 2 | 2 | 2 | D4309-1 | BUSHING |
| 1 | | | | | | D4357-041 | CREW STEP, LH |
| | 1 | | | | | D4357-042 | CREW STEP, RH |
| | | | | | | | |
| | | 4 | 4 | | | AN4-11A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | AN4-12A | BOLT |
| 2 | 2 | 2 | 2 | 2 | 2 | AN4-15A | BOLT |
| 6 | 6 | 6 | 6 | 6 | 6 | MS21042-4 | NUT |
| 6 | 6 | 6 | 6 | 6 | 6 | NAS1149D0463J | WASHER (AN960JD416) |

5.5 MAINTENANCE STEP PARTS LIST

| Qty -017 | Qty -018 | Qty -027 | Qty -028 | Qty -037 | Qty -038 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------------------------------|
| X | | | | | | D206-628-017 | MAINTENANCE STEP, LH 206A/B |
| | X | | | | | D206-628-018 | MAINTENANCE STEP, RH 206A/B |
| | | X | | | | D206-628-027 | MAINTENANCE STEP, LH 206L/L-1/L-3/L-4 |
| | | | X | | | D206-628-028 | MAINTENANCE STEP, RH 206L/L-1/L-3/L-4 |
| | | | | X | | D206-628-037 | MAINTENANCE STEP, LH 407 |
| | | | | | X | D206-628-038 | MAINTENANCE STEP, RH 407 |
| | | | | | | | |
| 2 | 2 | | | 2 | 2 | D2731-3RG | MOUNTING LUG |
| | | 2 | 2 | | | D2731-7RG | MOUNTING LUG |
| 2 | 2 | | | 2 | 2 | D3394-1RG | MOUNTING LUG |
| | | 2 | 2 | | | D3394-3RG | MOUNTING LUG |
| 2 | 2 | 2 | 2 | 2 | 2 | D4309-1 | BUSHING |
| | | 1 | | 1 | | D4342-041 | MAINTENANCE STEP, LH |
| | | | 1 | | 1 | D4342-042 | MAINTENANCE STEP, RH |
| 1 | | | | | | D4358-041 | MAINTENANCE STEP, LH |
| | 1 | | | | | D4358-042 | MAINTENANCE STEP, RH |
| | | | | | | | |
| 4 | 4 | 4 | 4 | 4 | 4 | AN4-12A | BOLT |
| | | 4 | 4 | | | AN4-13A | BOLT |
| 2 | 2 | 2 | 2 | 2 | 2 | AN4-15A | BOLT |
| 6 | 6 | 6 | 6 | 6 | 6 | MS21042-4 | NUT |
| 6 | 6 | 6 | 6 | 6 | 6 | NAS1149D0463J | WASHER (AN960JD416) |